

Work Order ID 60208



Page 1

Monday, June 28, 2010 3:10:33 PM

Item ID: D3183-045

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearing Assembly

Start Date: 6/28/2010 Start Qty: 25.00



Cust Item ID:

Required Date: 6/30/2010 Req'd Qty: 25.00

Customer:

Reference:

Run Start



Approvals: Process Plan: *MF*

Date: 10-6-28 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3183

Rev C1

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Turn D3183-9 Cap as per Folio FA388 Debur

SA 10/06/30

25 *φ*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

SA 10/06/30

25 *φ*

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

MF 10/06/30

25 *8*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

Press D3183-5 Bearing into D3183-9 Cap as per Dwg D3183.

4510/06/30 (25)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S10107101

canto
(25)

150



Packaging

Packaging

Identify as per dwg & Stock Location: 236

0.00

Memo

0.00

10.7 - 1 (25) SP

W/O:		WORK ORDER CHANGES						
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Cust Item ID:

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Customer:

Reference:

Run

Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/07/01 *[Signature]**mf*
10-7-01

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Picklist Print

Monday, June 28, 2010 3:10:33 PM

Page 1

Work Order ID: 60208

Parent Item: D3183-045

Parent Item Name: Bearing Assembly

Start Date: 6/28/2010

Required Date: 6/30/2010

Start Qty: 25.00

Required Qty: 25.00

Comments: IPP A04.02.18 New issue KJ/DS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3183-5

Manufactured

No

110

Each

38.0000

1

25



Bearing

Location

Loc Qty

Loc Code

ST236

38

47606

1

52135

2

59071

35

MDELIRINR1.000

Purchased

No

130

f

27.2400

0.0333

0.876316



Delrin Round Bar 1"

Location

Loc Qty

Loc Code

MAT

21.95

114733

21.95

MAT050

5.29

108804

5.29

25
5/10/06/30

25

Let no crooked toes
5/10/06/30

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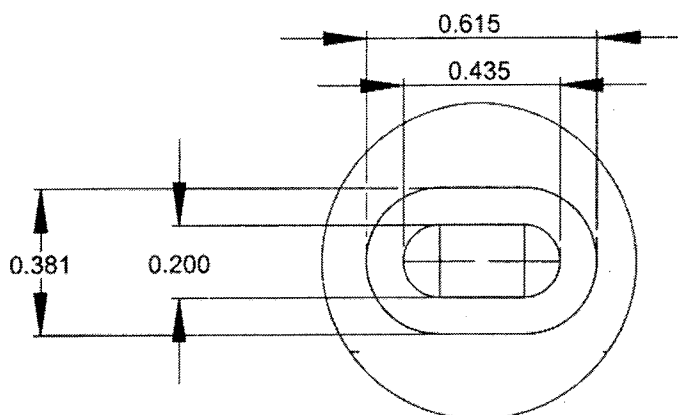
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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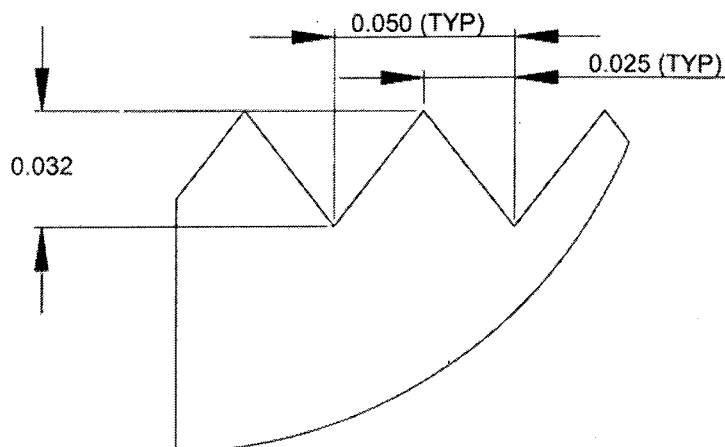
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3183	REV. C SHEET 4 OF 4
DATE 04.02.17	TITLE BRACKET ASSEMBLY		SCALE 1:1



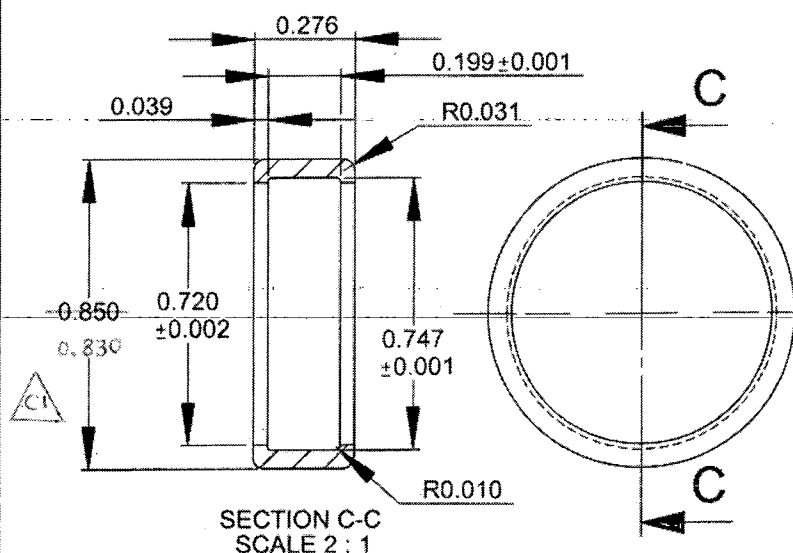
DETAIL A (2 : 1)

#60208

RELEASED
04.03.01



DETAIL B (20 : 1)



D3183-9 CAP

- 1) MATERIAL: DELRIN ROD, Ø1.00
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND
D3183-9 CAP

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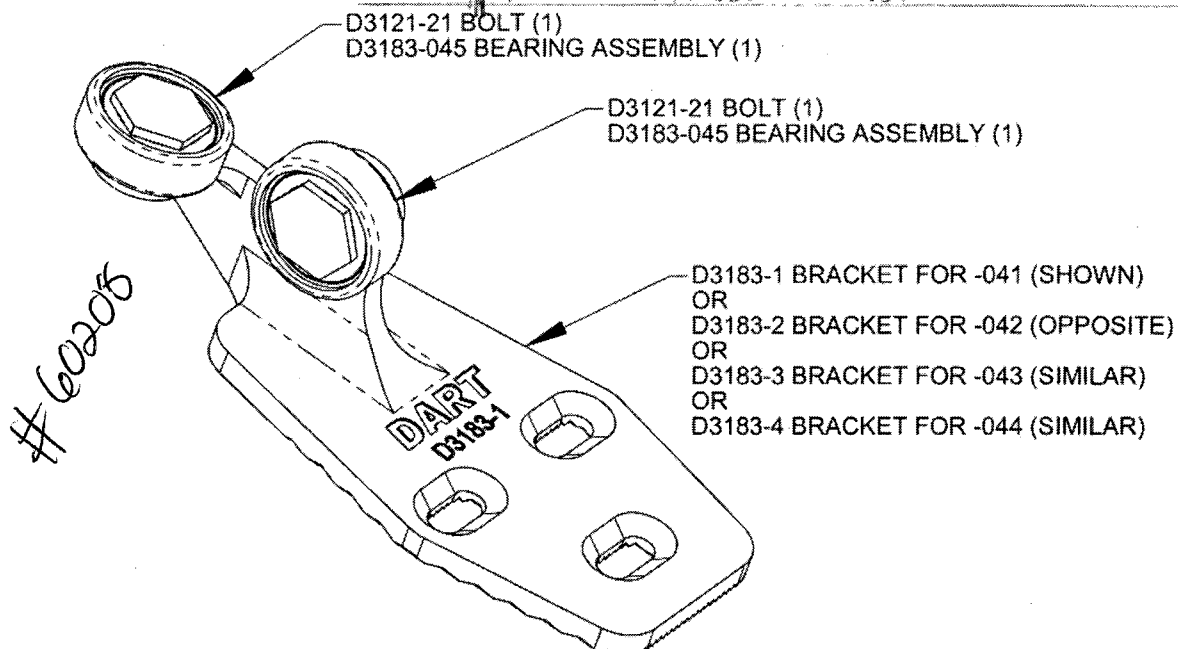
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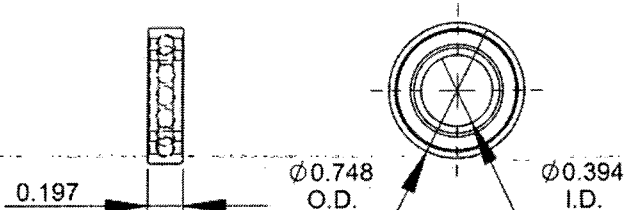


DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3183	REV. C SHEET 1 OF 4
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1
A	03.01.24	NEW ISSUE	
B	03.06.17	REMOVE BEARING; 1.012 WS 0.882	
C	04.02.17	ADD -045/-9; 0.182 WAS 0.431	
CI	# 04.11.09	0.830 WAS 0.850	

RELEASED
04.03.01

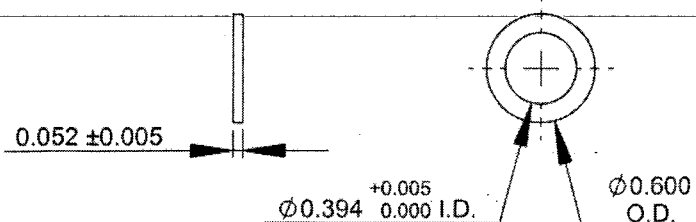


D3183-041 BRACKET ASSEMBLY (SHOWN)
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)



D3183-5 BEARING:
SPECIFICATION CONTROL DRAWING

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
- 3) ALL DIMENSIONS ARE IN INCHES



D3183-7 WASHER

- 1) MATERIAL: AISI 303 ROUND BAR (M303R) ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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